

Work Order ID 65177-2

Friday, January 07, 2011 9:00:21 AM



For Monday

Page 1

Item ID: D3121-241

Revision ID:

Item Name: Bearing Assembly

Start Date: 1/7/2011 Start Qty: 2.00

Required Date: 1/10/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Run Start

Stop



Approvals: Process Plan: *ms*

Date: 11-01-07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

1-Turn D3121-25 Cap as per Folio FA387-2-Deburr

SA 11/01/10

10 *φ*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SA 11/01/10

10 *φ*

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

SA 11/01/10

10 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65177

Friday, January 07, 2011 9:00:21 AM



Page 2

Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 1/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *NLF*

Date: 11-01-07 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

I-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

EP 11/07/11 (8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Sub 1/11

(XG)

150



Packaging

Packaging

Identify as per dwg & Stock Location *235A*

0.00

Memo

0.00

11/11 *Q* *ex*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65177

Friday, January 07, 2011 9:00:21 AM

Page 3

Item ID: D3121-241

Accept

Revision ID:

Item Name: Bearing Assembly

Start Date: 1/7/2011 Start Qty: 2.00

Required Date: 1/10/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/11
CME
11-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, January 07, 2011 9:00:21 AM

Page 1

Work Order ID: 65177



Parent Item: D3121-241



Parent Item Name: Bearing Assembly

Start Date: 1/7/2011

Required Date: 1/10/2011

Start Qty: 2.00

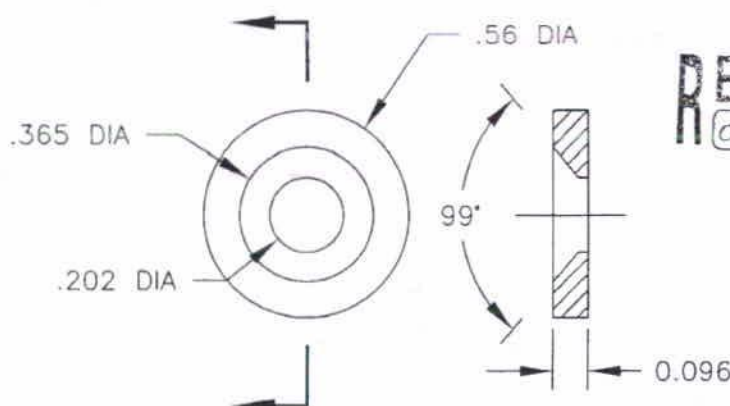
Required Qty: 2.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

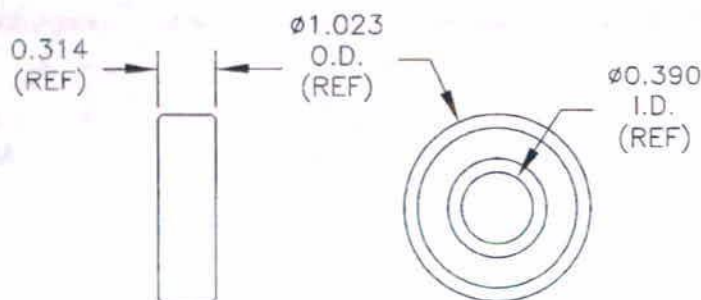
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000 Delrin Round Bar 1"		Purchased	No			100	f	24.0000	0.052	0.104		11/01/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				24					
				116266				24					
D3121-23 Bearing		Manufactured	No			130	Each	37.0000	1	2		11/01/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				37					
				56591				2					
				60708				1					
				64123				34					

DART

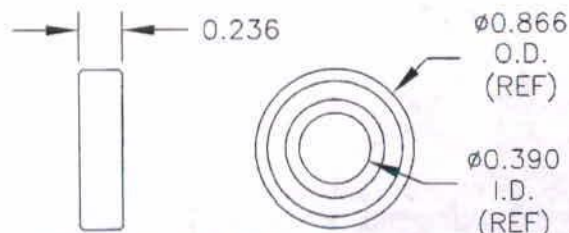
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

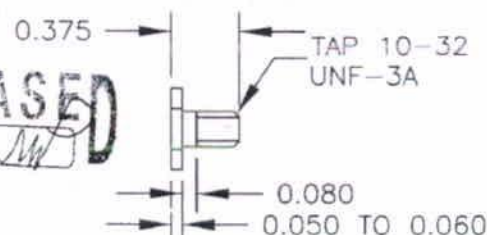
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

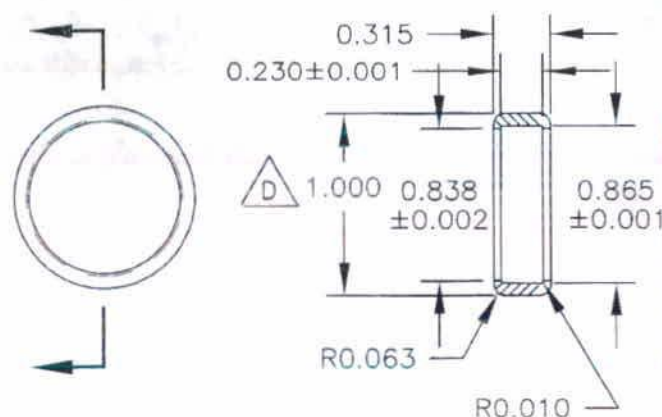
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

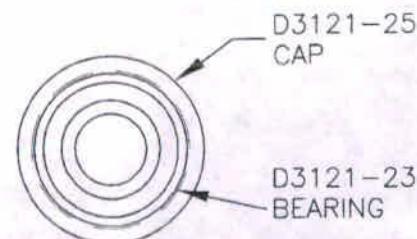
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, ϕ 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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